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3. That the attached is, to the best of RWS Group plc knowledge and belief, a true translation into the English language of the accompanying copy of the specification filed with the application for a patent in Germany on 2 October 1997 under the number 197 43 748.6 and the official certificate attached hereto.
4. That I believe that all statements made herein of my own knowledge are true and that all statements made on information and belief are true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the patent application in the United States of America or any patent issuing thereon.

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BASF Aktiengesellschaft
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have filed a Patent Application under the title:

“Esters as solvents in electrolyte systems for Li-ion storage cells”

on 2 October 1997 at the German Patent Office.

The attached documents are a correct and accurate reproduction of the original submission for this Patent Application.

The German Patent Office has for the time being given the Application the symbols H 01 M, C 07 F and C 07 C of the International Patent Classification.

Munich, 8 September 1998
President of the German Patent Office
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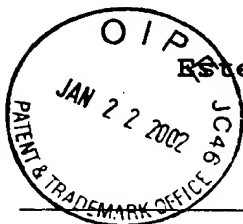
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**Esters as solvents in electrolyte systems
for Li-ion storage cells**

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The invention relates to the use of specific esters of boric acid, carbonic acid, silicic acid, phosphoric acid and sulfuric acid as a solvent in electrolyte systems for Li-ion storage cells, to a composition comprising them and to Li-ion storage cells which contain these esters.

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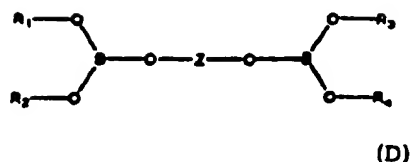
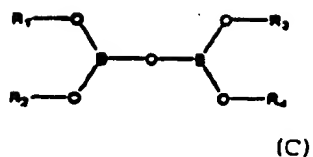
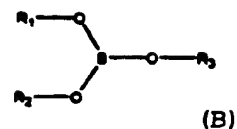
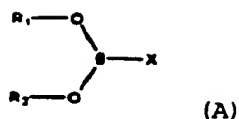
Until now, the solvents predominantly used in Li storage cells are alkyl ethers such as dimethyl ether, and alkene carbonates such as ethylene carbonate (EC) and propylene carbonate (PC). Such systems are described, inter alia, in JP 08 273 700 and JP 09 115 548.

Also known, in addition, are electrolyte solutions based on various esters.

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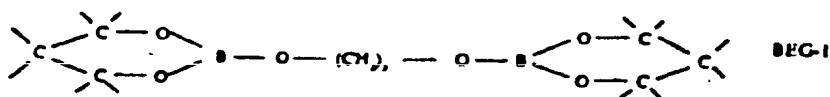
Thus, WO97/16862 describes an electrolyte solution which comprises boric acid esters of the following formulae (A) to (D):

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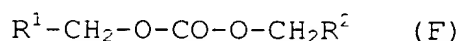


where X is halogen, R^1 , R^2 , R^3 and R^4 are straight-chain or branched-chain aliphatic or aromatic alkyls which may be substituted by substituents of various electronegativities and Z is a straight-chain or branched-chain aliphatic or aromatic alkyl or siloxane group.

10 An electrolyte solvent for rechargeable lithium and lithium-ion batteries based on a boric acid ester referred to as BEG-1, of the following formula (E), in combination with EC and/or PC is described in J. Electrochem. Soc., 143, p. 4047-4053, 1996.



EP-B 0 599 534 describes carbonate compounds of the following formula (F)



where R^1 is a hydrogen, an alkyl or an alkyl substituted by one or more halogen atoms, and R^2 is an alkyl which does not contain any α -position hydrogen or is an alkyl

which is substituted by one or more halogen atoms and contains no α -position hydrogen, with the proviso that R^1 is not identical with R^2 , excluding the compound $C_2H_5-O-CO-O-CH_2-(CF_2)_4-H$, and the use of said carbonate
5 compounds in a nonaqueous electrolyte solution.

EP-A 0 698 933 relates to a nonaqueous secondary cell which comprises a specific electrolyte solution comprising, inter alia, triesters of phosphoric acid of
10 the formula $(RO)_3P=O$, wherein the groups R are identical or different and in each case are a C_1 - to C_6 -alkyl, or two RO groups together with the phosphorus atom to which they are bound may form a ring. Such alkyl phosphates and the use thereof in nonaqueous electrolyte solutions
15 and secondary cells are also described in EP-A 0 696 077.

The use of phosphoric acid esters of the formula $O=P(-O-(CH_2CH_2O)_qR^2)_3$, where n and q are from 1 to 10 and
20 R^2 is a C_1 - to C_4 -alkyl, as an electrolyte in zinc batteries are [sic] described in JP 07 161 357.

Further phosphoric acid esters comprising hydrocarbon groups, and their use as an electrolyte in lithium-ion
25 batteries are described in JP 58 206 078.

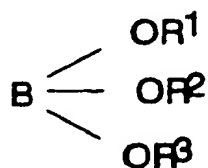
JP 61 256 573 describes an electrolyte based on a polymer of a phosphoric acid ester which comprises at
30 least one polymerizable group.

One of the conclusions to be drawn from the above summary of the prior art is the fact of the prior
existence of several electrolyte systems comprising esters based on boric acid esters, carbonic acid esters
35 or phosphoric acid esters. The above-described systems

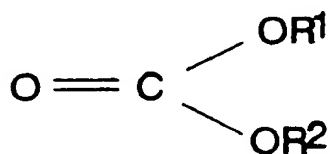
do not, however, meet the ever-increasing demands made of such electrolyte systems or do so but inadequately.

For example, such electrolyte systems are to exist in the liquid phase over a relatively large temperature range while maintaining a low vapor pressure. They are to have a low viscosity in order thus to ensure sufficiently high conductivity. Moreover they are to be electrochemically and chemically stable and be sufficiently resistant to hydrolysis. In addition, such solvents should be capable of strong solvation of the ions of the conducting salts.

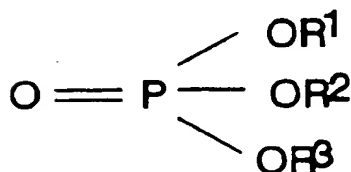
In view of the above prior art, it was an object of the present invention to provide novel solvents for electrolyte systems for Li-ion storage cells, which meet the increasing demands made of these solvents. The present invention therefore relates to the use of at least one ester of the formula (I) to (V)



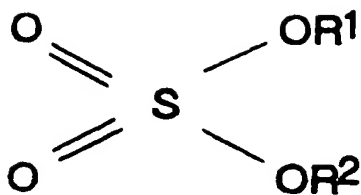
(I)



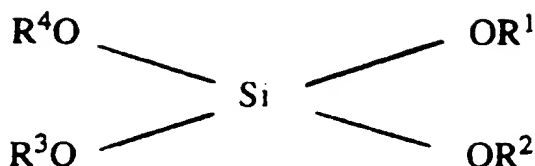
(II)



(III)



(IV)



(V)

where R^1 , R^2 , R^3 , R^4 are identical or different and each, independently of one another, are a linear or branched-chain C_1 - to C_4 -alkyl, $(-\text{CH}_2-\text{CH}_2-\text{O})_n-\text{CH}_3$ with $n = 1$ to 3, a C_3 - to C_6 -cycloalkyl, an aromatic hydrocarbon group which in turn can be substituted, with the proviso that at least one of the groups R^1 , R^2 , R^3 or R^4 is $(-\text{CH}_2-\text{CH}_2-\text{O})_n-\text{CH}_3$ with $n = 1$ to 3, as a solvent in electrolyte systems for Li-ion storage cells.

Among the abovementioned esters of formulae (I) to (V), the phosphoric acid esters of formula (III) are used preferentially.

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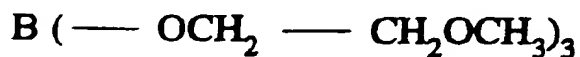
Examples of the groups R^1 , R^2 and, where present, R^3 and/or R^4 are methyl, ethyl, n- and isopropyl, n- and t-butyl, cyclopentyl, cyclohexyl and benzyl, and also $(-\text{CH}_2-\text{CH}_2-\text{O})_n-\text{CH}_3$ where $n = 1$ to 3, although it should be noted, as previously mentioned, that at least one of the groups R^1 , R^2 , R^3 or R^4 is $(-\text{CH}_2-\text{CH}_2-\text{O})_n-\text{CH}_3$ with $n = 1$ to 3, preferably 1 or 2.

Greater preference is given to the use of esters of the formulae (I) to (V) in which R^1 , R^2 and, where present,

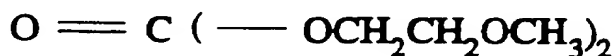
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R³ and/or R⁴ are identical and are -CH₂-CH₂O-CH₃ or (-CH₂-CH₂-O)₂-CH₃, preference again being given to the corresponding phosphoric acid esters.

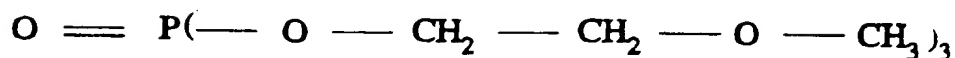
- 5 Examples of especially preferred compounds are the compounds of formulae (Ia) to (Va).



(Ia)

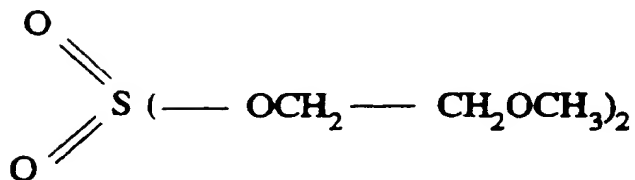


(IIa)

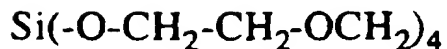


(IIIa)

10 and



(IVa)



(Va)

- 15 The esters used herein are eminently suitable, in terms of their properties, as solvents in electrolyte systems for Li-ion storage cells and generally have a viscosity, at room temperature, of ≤ 10 mPaS, preferably ≤ 5 mPaS and in particular ≤ 3 mPaS. They have boiling points of,

in general, about 200°C or more, preferably about 250°C or more and in particular about 300°C or more, in each case measured at atmospheric pressure, and have a sufficiently low vapor pressure, from roughly about 10⁻⁵ to about 10⁰ [lacuna] at the temperatures of about -50°C to about 150°C encountered in the course of their use, so that they do not have an adverse effect on the characteristics of the Li-ion storage cell. Their boiling points mean that they are distillable and can therefore, in the course of their preparation, be obtained with high purity. Moreover, these esters, of a wide temperature range, are liquid at atmospheric pressure, generally still being liquid over a range extending as far as about -30°C, preferably as far as about -40°C. The esters described in this context can be employed as a solvent in electrolyte systems for Li-ion storage cells at at least about 80°C, preferably at at least about 120°C, more preferably at at least about 150°C.

20

Obviously, the esters used according to the invention can also be employed as a mixture with known solvents for electrolyte systems, e.g. the alkyl ethers mentioned at the outset, such as dimethyl ether, diethyl ether, dioxalane, diglyme, tetraglyme, 1,2-dimethoxyethane, tetrahydrofuran, 2-methyltetrahydrofuran, etc., and alkylene carbonates such as ethylene carbonate, propylene carbonate, butylene carbonate, γ -butyrolactone, and linear esters such as diethyl carbonate, dimethyl carbonate etc. Again, it is possible to employ a combination of at least one of the esters used according to the invention and at least one further solvent known from the prior art.

30

Preference is given to solvent combinations which have sufficiently low viscosity, are capable of strong solvation of the ions of the conducting salts, are liquid over a wide temperature range and are adequately electrochemically and chemically stable and resistant to hydrolysis.

Furthermore, the esters employed according to the invention can also be employed in combination with polymer electrolytes, such as polymerization products, of boric acid esters, carbonic acid esters, silicic acid esters, phosphoric acid esters and sulfuric acid esters, whose constitution as a rule is such that at least one of the ester groups comprises a polymerizable unit such as a C=C double bond, and/or esters of the corresponding polyacids, for example polyphosphoric acid esters or polysilicic acid esters, and/or other conventional polymer electrolytes, the content of the esters used according to the invention [lacuna] from about 5 to 100 wt%, preferably from about 20 wt% to 100 wt% and more preferably from about 60 wt% to 100 wt%, the total from ester and polymer electrolyte in each case adding up to 100 wt%.

The esters used according to the invention were prepared according to conventional methods, as described, for example, in K. Mura Kami in Chem. High Polymers (Japan), 7, p. 188-193 (1950) and in H. Steinberg, Organoboron Chemistry, Chapter 5, J. Wiley & Sons, N.Y. 1964. This generally involves starting from the acids, acid anhydrides or chlorides on which the esters are based, e.g. from boric acid, $C(O)Cl_2$, $POCl_3$, SO_2Cl_2 and $SiCl_4$, these being reacted in a known manner with the corresponding mono- or polyhydric alcohols or etherols.

The esters employed according to the invention can be combined in combination with any of the conducting salts, as described, for example in EP-A 0 096 629, used hitherto for Li-ion storage cells. The use according to
5 the invention preferably involves the use, as conducting salt, of LiPF_6 , LiBF_4 , LiClO_4 , LiAsF_6 , LiCF_3SO_3 , $\text{LiC}(\text{CF}_3\text{SO}_2)_3$, $\text{LiN}(\text{CF}_3\text{SO}_2)_2$, $\text{LiN}(\text{CF}_3\text{CF}_2\text{SO}_2)_2$, $\text{LiN}(\text{SO}_2\text{F})_2$, LiAlCl_4 , LiSiF_6 , LiSbF_6 or a mixture of two or more thereof, the conducting salt used preferentially being
10 LiBF_4 . Particular preference is given to the use of the combination of the esters of formulae (Ia) to (IVa) in conjunction with LiBF_4 as conducting salt, particular preference again being given to the combination of the ester of formula (IIIa) with LiBF_4 as conducting salt.

15

The invention therefore also relates to an Li storage cell which comprises at least one ester as defined above.

20 Furthermore, the present invention relates to a composition comprising:

(A) at least one compound of formula (I) to (V) as defined above, and

25

(B) a conducting salt selected among:

LiPF_6 , LiBF_4 , LiClO_4 , LiAsF_6 , LiCF_3SO_3 , $\text{LiC}(\text{CF}_3\text{SO}_2)_3$,
 $\text{LiN}(\text{CF}_3\text{SO}_2)_2$, $\text{LiN}(\text{SO}_2\text{F})_2$, $\text{LiN}(\text{CF}_3\text{CF}_2\text{SO}_2)_2$, LiAlCl_4 ,
30 LiSiF_6 , LiSbF [sic] and a mixture of two or more thereof,

this composition preferably comprising, as the compound (A), at least one ester of formulae (Ia) to (Va), more

preferably the ester of formula (IIIa), in each case in conjunction with LiPF_6 and/or LiBF_4 as compound (B).

5 The solution of compound (B) in compound (A) is generally from about 0.2 to about 3 molar, preferably from about 0.5 to about 2 molar, more preferably from about 0.7 to about 1.5 molar.

10 Furthermore, the present invention relates to the use of the above-defined composition as an electrolyte system in Li-ion storage cells and to an Li-ion storage cell comprising a composition as defined above.

15 Within the scope of the novel Li-ion storage cell it is possible to use any of the cathode materials customary for Li-ion storage cells, such as LiCoO_2 , LiNiO_2 , Li_xMnO_2 ($0 < x \leq 1$), $\text{Li}_x\text{Mn}_2\text{O}_4$, ($0 < x \leq 2$), Li_xMoO_2 ($0 < x \leq 2$), Li_xMnO_3 ($0 < x \leq 1$), Li_xMnO_2 ($0 < x \leq 2$), $\text{Li}_x\text{Mn}_2\text{O}_4$ ($0 < x \leq 2$), $\text{Li}_x\text{V}_2\text{O}_4$ ($0 < x \leq 2.5$), $\text{Li}_x\text{V}_2\text{O}_3$ ($0 < x \leq 3.5$), Li_xVO_2 ($0 < x \leq 1$), Li_xWO_2 ($0 < x \leq 1$), Li_xWO_3 ($0 < x \leq 1$), Li_xTiO_2 ($0 < x \leq 1$), $\text{Li}_x\text{Ti}_2\text{O}_4$ ($0 < x \leq 2$),
20 Li_xRuO_2 ($0 < x \leq 1$), $\text{Li}_x\text{Fe}_2\text{O}_3$ ($0 < x \leq 2$), $\text{Li}_x\text{Fe}_3\text{O}_4$ ($0 < x \leq 2$), $\text{Li}_x\text{Cr}_2\text{O}_3$ ($0 < x \leq 3$), $\text{Li}_x\text{Cr}_3\text{O}_4$ ($0 < x \leq 3.8$), $\text{Li}_x\text{V}_3\text{S}_5$ ($0 < x \leq 1.8$), $\text{Li}_x\text{Ta}_2\text{S}_2$ ($0 < x \leq 1$), Li_xFeS ($0 < x \leq 1$), Li_xFeS_2 ($0 < x \leq 1$), Li_xNbS_2 ($0 < x \leq 2.4$), Li_xMoS_2 ($0 < x \leq 3$), Li_xTiS_2 ($0 < x \leq 2$), Li_xZrS_2 ($0 < x \leq 2$), Li_xNbSe_2 ($0 < x \leq 3$), Li_xVSe_2 ($0 < x \leq 1$), Li_xNiPS_2 ($0 < x \leq 1.5$), Li_xFePS_2 ($0 < x \leq 1.5$) and a mixture of two or more of these, possibly together with a binder such as polytetrafluoroethylene and poly(vinylidene fluoride).

30 The anode material used may likewise be any of the anode materials customarily employed in Li-ion storage cells, such as metals, for example metallic lithium, lithium-containing metal alloys, a metal sulfide or a carbon-

containing material, especial preference being given to carbon-containing materials which are capable of storing and releasing lithium ions. To be mentioned among carbon-containing materials of this type are natural and
5 synthetic graphite or amorphous carbon such as activated carbon, carbon fibers, synthetically graphitized coal dust and carbon black. It is also possible to use oxides such as titanium oxide, zinc oxide, tin oxide, molybdenum oxide, tungsten oxide, and carbonates such as
10 titanium carbonate, molybdenum carbonate and zinc carbonate.

Further details regarding suitable anode and cathode materials and the fabrication of the Li-ion storage
15 cells can be gathered from the prior art mentioned at the outset, which is incorporated by reference.

If required, the solvent according to the invention may also be admixed with solids such as SiO_2 and Al_2O_3 .

20 The fabrication of the Li-ion storage cells generally involves the coating of the current collector electrodes with the anode or cathode material, the insertion of spacers e.g. made of stretched polypropylene, and the
25 addition of the electrolyte, after which this system consisting of cathode, anode, spacer and electrolyte is wrapped and inserted into a jacket.

The present invention will now be explained in more
30 detail with reference to a few examples according to the invention and with the aid of Figures 1 to 3,

where Figure 1 depicts a cyclic voltammogram (CV) in the voltage window from 0 to 4.3 V, recorded with the
35 test cell according to Example 2,

Figure 2 depicts a CV in the voltage window of a lithium-ion battery from 3.3 to 4.3 volts, recorded with the test cell according to Example 3,

5

Figure 3 depicts a CV in the voltage window of from 2.75 to 4.5 volts, recorded with the test cell according to Example 4.

10 **EXAMPLE 1**

To prepare the phosphoric ester of formula $\text{O=P}(-\text{O}-\text{CH}_2-\text{CH}_2-\text{OCH}_3)_3$, 274 g (3.6 mol) of methylglycol together with 2 g of ZnCl_2 were introduced as the initial charge into a
15 1,000 ml round-bottomed flask and cooled to 5°C. Then, 153.33 g (1 mol) of POCl_3 were added dropwise over a period of 50 min, the temperature being maintained at approximately 5°C to 10°C. After the addition was complete, a clear solution was obtained which was
20 allowed to warm to room temperature. The product mixture obtained was then distilled in vacuo (80 to 90 mbar) at about 50°C to 55°C, to remove unreacted starting material and by-products.

25 Distillation then continued in high vacuum (about 0.02 mbar) at about 170°C, affording the desired product. The water content of the above phosphoric ester was 20 ppm.

EXAMPLE 2

30

The product of composition $\text{O=P}(-\text{O}-\text{CH}_2-\text{OCH}_3)_3$ and a highly pure conducting salt LiPF_6 were used in the preparation, under an inert-gas atmosphere, of a 0.1 M electrolyte. This electrolyte was then used in the assembly of a 3-
35 electrode cell comprising platinum as the working

electrode, platinum as the counterelectrode and a Li metal strip as the reference electrode for electrochemical measurements.

5 This electrochemical test cell was then used to record a cyclovoltammogram in the voltage window from 0 to 4.3 volts versus Li/Li⁺, to determine the electrochemical stability of this solvent.

10 The measuring conditions were as follows:

Starting from the open-circuit potential, oxidation was first carried out as far as 4.3 V, at a constant scan rate of 0.1 mV/sec, followed by reduction as far as 3.0 [sic] V. Subsequently, a further cycle was run in
15 this voltage window. Figure 1 shows that the abovementioned phosphoric acid ester is electrochemically inert in the voltage range customarily used in rechargeable lithium-ion batteries and is therefore suitable as an electrolyte solvent.

20

EXAMPLE 3

By a method similar to that of Example 2, an electrochemical 3-electrode test cell was again
25 assembled, except that this time a 0.5 M LiPF₆/O=P(-O-CH₂-OCH₃)₃ electrolyte was used. The working electrode used in this case was an Li-manganese spinel coating of [sic] aluminum foil, and Li metal was used as the counter and the reference electrode.

30

In the typical voltage window of a lithium-ion battery, from 3.3 to 4.3 volts, a cyclovoltammogram was again run at a scan rate of 0.01 mV/sec, which is realistic for batteries.

35

As can be seen from Figure 2, the twin redox peak, typical for such a spinel, was produced both in the course of oxidation (= extracalation of the Li ions from the spinel host lattice) and of reduction (= intercalation of Li ions into the spinel host lattice). The electrolyte used can therefore be employed for rechargeable lithium-ion batteries comprising Li-manganese spinel cations.

10 **EXAMPLE 4**

The product of composition $\text{O}=\text{P}(-\text{O}-\text{CH}_2-\text{OCH}_3)_3$ and a highly pure conducting salt LiBF_4 having a concentration of 1 M in the ester $\text{O}=\text{P}(-\text{O}-\text{CH}_2-\text{OCH}_3)_3$ were used in the preparation, under an inert-gas atmosphere, of a 0.1 M electrolyte.

Measuring conditions:

Starting from the open-circuit potential, oxidation was first carried out [lacuna] 4.3 V vs. Li/Li^+ , at a scan rate of 0.33 mV/sec, followed by reduction as far as 3.3 V. Subsequently, 2 full cycles were run in this voltage window.

As Figure 3 shows, this electrolyte too is stable in the voltage window of the lithium-ion battery and can thus be used as an electrolyte system.